

Perew. 57047 Split

Work Order ID 52354 - 2



Tuesday, September 22, 2009 12:26:55 PM

Item ID:	D3023-1 <i>MP</i>	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Back Panel					
Start Date:	9/23/2009	Start Qty:	6.00 <i>2W</i>	Cust Item ID:		
Required Date:	10/9/2009	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	<i>RF MF</i>	Date:	<i>09 9 22</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3023	Rev A

100	FLOW WATER JET	0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3023								
<i>2071</i>	Dwg Rev: <i>17</i>								
<i>.635</i>	Prog Rev: <i>17</i>								
	***graind direction along 28.100" ***								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B 9-11-5

③

B 9-11-5

Work Order ID 52354

Tuesday, September 22, 2009 12:26:56 PM



Page 2

Item ID: D3023-1

Revision ID: A

Item Name: Back Panel

Start Date: 9/23/2009 Start Qty: 6.00

Required Date: 10/9/2009 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 Scribble

(43) /

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1-Bend as per Dwg D3023 12-form edge of back pan as per dwg D3023 using
D3017-041 back frame

20 215 10/02/09

EL 10-3-8

(3)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S10103110

(40)

Work Order ID 52354



Page 3

March 10, 2010 1:34:13 PM

Item ID: D3023-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Back Panel

Start Date: 9/23/09 Start Qty: 6.00



Cust Item ID:

Required Date: 10/09/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:00am

OVEN TEMPERATURE:

10:30am FINISH TIME:

320°F

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Page 4



Stop



Cust Item ID:

Customer:

Reference:

Run Start

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Insp.
Stamp

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/17 J

mF 10-3-16

Picklist Print

Tuesday, September 22, 2009 12:26:55 PM

Page 1

Work Order ID: 52354



Parent Item: D3023-1RevA



Parent Item Name: Back Panel

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

100

sf

94.2179

18.1749

10.0



18 9-11-5

2024-T3 .032 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

94.21793158

102942

1.5

105555

4.0684

106272

5.3

108595

3

109240

7.02

110778

23.9106316

111699

46.4189

18147

3

~~113005~~ 110305

113005

DART AEROSPACE LTD		Work Order: 52354
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	130	X			
Ø0.191	+0.005/-0.001	194	X			
1.660	+/-0.010	1.666	X			
0.375	+/-0.010	0.377	X			
1.340	+/-0.010	1.344	X			
2.375	+/-0.010	2.373	X			
0.375	+/-0.010	0.373	X			
25.28	+/-0.030	25.28	X			
27.03	+/-0.030	27.03	X			
28.10	+/-0.030	28.10	X			
1.30	+/-0.030	1.297	X			
2.375	+/-0.010	2.373	X			
8.711	+/-0.010	8.712	X			
5.597	+/-0.010	5.598	X			
8.57	+/-0.030	8.571	X			
1.970	+/-0.010	1.967	X			
7.42	+/-0.030	7.420	X			
10.92	+/-0.030	10.92	X			
14.75	+/-0.030	14.75	X			

Measured by: AB
Date: 9-11-5

Audited by: S
Date: 01/10/06

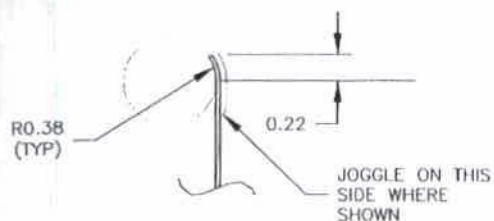
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	

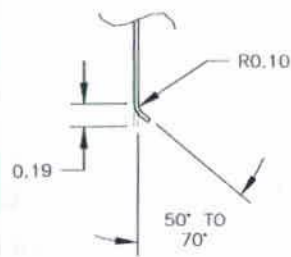
SHOP COPY
RETURN TO
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UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52354

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

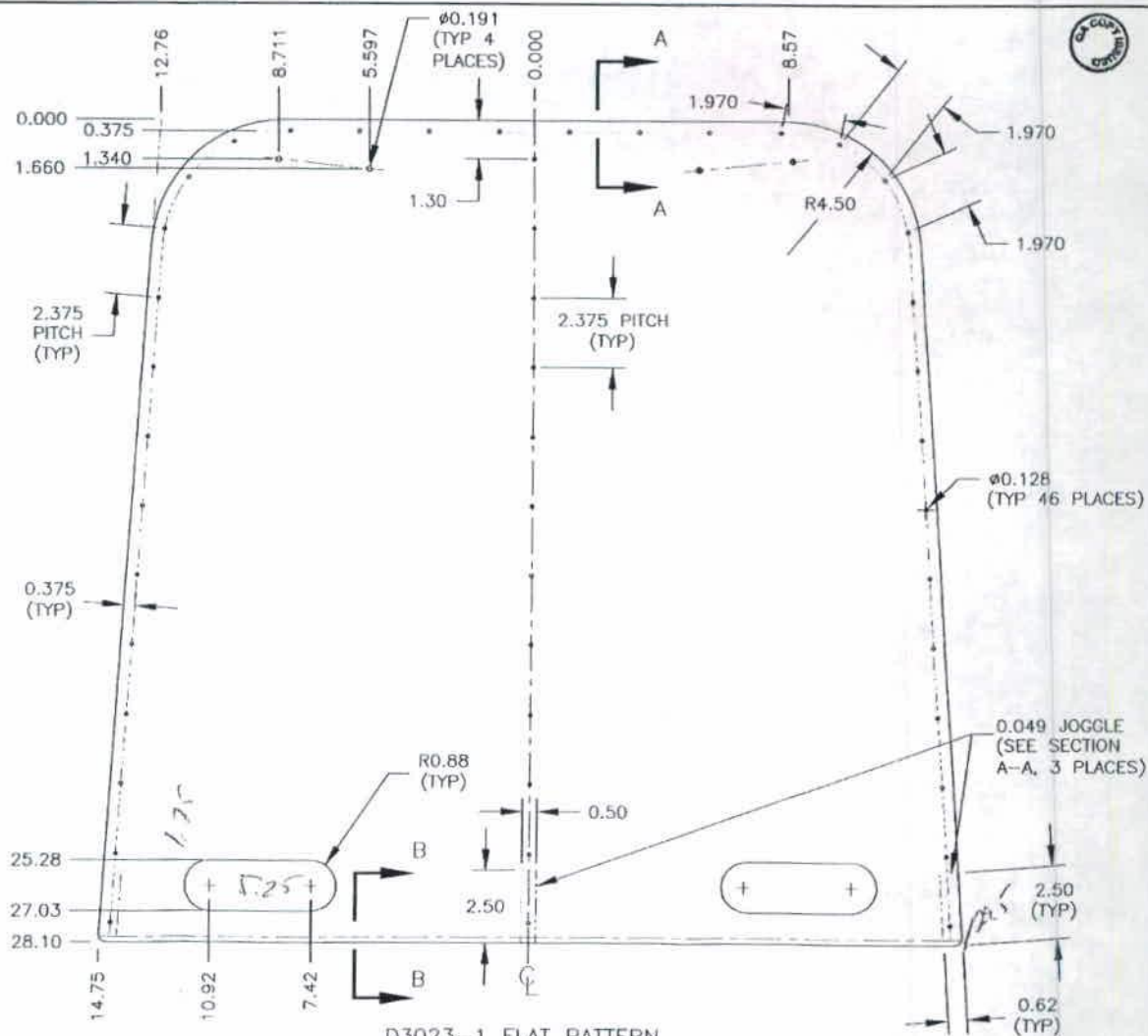


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALDINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	CP	APPROVED	CP
DATE	01.05.18	DRAWING NO.	D3023
		TITLE	BACK PANEL
		REV. A	SHEET 1 OF 1
		SCALE	1:4

DART

DART AEROSPACE LTD.
BIRMINGHAM, CHINA